

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014903**Date Inspected:** 19-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Geng wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 3G-004 located on PCMK SEG3001C of Segment 12AE welder is identified as 206623. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 4G-019 located on PCMK SEG3001AA of Segment 12AE welder is identified as 037896. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 2G-010 located on PCMK SEG3001AA of Segment 12AE welder is identified as 044790. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 3G-003 located on PCMK SEG3004D of Segment 12AW welder is identified as 047866. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 2F-009 located on PCMK SEG3006G of Segment 12CW welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

201215. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#19

Fit-up of bearing plate is in progress on BK004A-005.

FCAW welding of weld joint 2G-055 located on PCMK SB013-062 of Lift 8 welder is identified as 062738. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-049 located on PCMK SB013-066 of Lift 8 welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

Ongoing Heat straightening of FL-3 bottom plate is identified as BP026-015-04~23, 043~53 is checked with ZPMC QC Mr. Xu tao is appeared to comply with HSR-8011.

OUTSIDE SHOP

SMAW welding of critical weld repair joint 2G-004 located on PCMK CA080 of Segment 11AW welder is identified as 050232. ZPMC QC is identified as Mr. Wang wei ming . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-repair-1 and B-CWR1527. During this critical weld repair work no ZPMC CWI present since from morning 8.00 clock to 10.00 clocks.

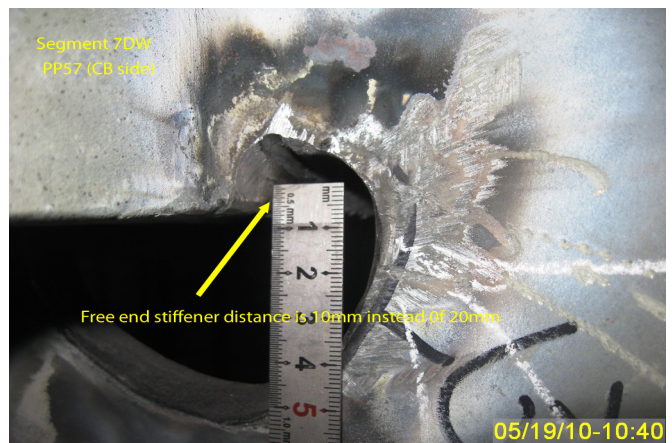
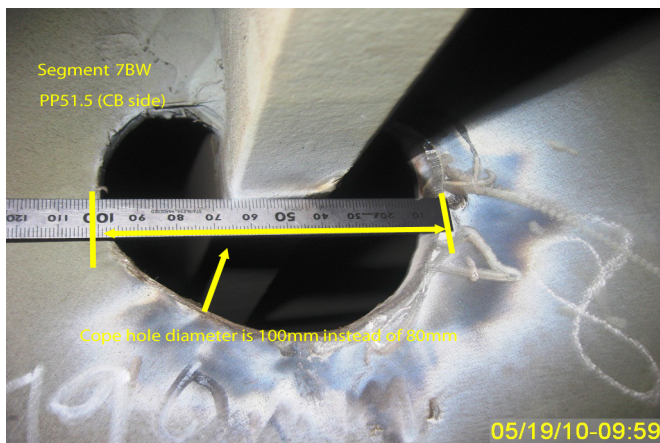
TRAIL ASSEMBLY YARD

VT inspection of Corner assembly cope holes dimension measured with ZPMC QC Mr. Zhang qiang from lift 7AW ~7EW as per drawing. Most of the location cope hole diameter is out of design tolerance and free end stiffener height also lot of location is less than the required, areas need additional grinding marked and informed to ZPMC QC.
See the attached photos for more information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
